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D206-642-311BL
Job Sheet 186089



Part No: D206-642-311BL

Job Qty: 1 ea

Part Name: Skidtube LH (Ael Blue)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/9/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV Q SHEETS 29-30 IPP Rev:J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC IPP Rev:K 07-12-04 ECN 1080p DD verified by:ec IPP Rev:L 08-09-29 as per DSI9421 DD verified by:EC IPP Rev:M as per REV.N DD 10.04.19 verified by:EC IPP Rev:N 14.04.25 ECN14-520 DD verf:JLM IPP REV:O 15.10.09 ADDED BL DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/14/18	12/14/18	0.00	0.00	Start Up Stores/Pkg-1		NOV 30 2018
110	Packaging	1 pcs	12/14/18	12/14/18	0.00	0.00	Packaging1-2		DAS 69
120	QC	1 pcs	12/14/18	12/14/18	0.00	0.00	QC4	DEC 1 1 2018	DAS 9-89
125	DC	1 pcs	12/14/18	12/14/18	0.00	0.00	DC		DAS 21
130	Packaging	1 pcs	12/14/18	12/14/18	0.00	0.00	Packaging3-1	DEC 1 1 2018	DAS 21
140	QC21-FG	1 Ea	12/14/18	12/14/18	0.00	0.00	QC21		DAS 21

Part Op 110 - Pick Kit

Descriptions: 120 - QC4- 100% Inspect kits for completeness

125 - Document Control Photocopy bluefile and create labels per PPP D206-642-311 CHG008

130 - Identify as per dwg & Stock Location: _____ Identify and pack for shipping as per PPP D206-642-311 Location:

_____ PPP Rev: _____

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-41A	Bolt	8 Ea (8 ea)	90-Start up Operation	5038750
AN4-6A	Bolt	12 Ea (12 ea)	90-Start up Operation	5053945
AN4C5A	Bolt	1 Ea (1 ea)	90-Start up Operation	5019407
AN5-10A	Bolt	4 Ea (4 ea)	90-Start up Operation	5089283
AN5-11A	Bolt	8 Ea (8 ea)	90-Start up Operation	5003927
AN5-12A	Bolt	4 Ea (4 ea)	90-Start up Operation	5003926
D206-642-341BL	Replacement Skidtube (Fits LH or RH)	1 Ea (1 ea)	90-Start up Operation	5128394
D206-648-013BL	Ground Handling Wheel Modification	1 Ea (1 ea)	90-Start up Operation	5136780
D2652	Bushing	16 Ea (16 ea)	90-Start up Operation	5122721
D2712	Set Screw	10 Ea (10 ea)	90-Start up Operation	5059551
D2932-1BL	Saddle LH Out, 206	1 Ea (1 ea)	90-Start up Operation	5131240
D2933-1BL	Saddle LH In, 206	1 Ea (1 ea)	90-Start up Operation	5056626
D2934	Saddle Spacer	2 Ea (2 ea)	90-Start up Operation	5054584
D2935	Saddle Spacer	2 Ea (2 ea)	90-Start up Operation	5054582
D2938-1BL	Saddle LH Out, 206	1 Ea (1 ea)	90-Start up Operation	5052488
D2939-1BL	Saddle LH In, 206	1 Ea (1 ea)	90-Start up Operation	5129738

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date: _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval _____																	
Reason Work Order Deviation _____		Disposition _____																			
DART AEROSPACE Container No: S136874 Part: D206-642-311BL Job No: 186089 Serial No/Batch: S136874 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: TC STC SH98-4 Issue 2015 Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1-800-363-632-5200 TEL: 1-800-363-632-5200 TEL: 1-800-363-632-5200 www.dartaerospace.com		Completed By _____																			
		Lead hand / Supervisor Approval Verification _____																			
		QC / QA Coordinator Approval _____																			
Equipment _____		FAULT CATEGORY																			
Handling/Pre _____ Material _____ Internal Transport _____ Tribal Knowledge _____ LOA _____ Substation _____ Past Expiry Date _____ Misidentified _____	Supplier _____ Training _____ Use for Testing _____ Poor Information _____ Rushing _____ Product Improvement _____ Process Improvement _____ Manufacturing Process _____ Past Due _____	Pressure/Forced _____ Bending _____ Centre Not Concentric _____ Cracks _____ Crimp/Kink/Ripple/Wave _____ Cuffs _____ Crushing _____ Heat Treat _____ Wave/Twist in Tube _____ Marks/Chatter _____	Temperature/Cure _____ Set-up _____ BOM/Route _____ Broken/Damage/Defect _____ Inspection Incomplete/Unqualified _____ Contamination _____ Countersink _____ Cut Too Short _____ Instructions Incomplete/Unclear _____ Drill Holes _____	Power Loss/Surge _____ Folio/Program _____ Grain _____ Weld _____ Wrong Stock Pulled _____ Out of Sequence _____ Off-set _____ Mislabeled _____ Fit/Function _____ Misaligned/off center _____	Positioned Wrong _____ Outside Dimensions _____ Over/Under tolerance _____ Part Incorrect _____ Part Lost/Missing _____ Part Moved _____ Drawing _____ Finish _____ Misread _____ Turning Sequence _____																
OTHER : _____																					

D3407-043BL	Tow Ring, Blue Prime/Paint	1 Ea (1 ea)	90-Start up Operation	5063079
D3413-1BL	O-Ring	1 Ea (1 ea)	90-Start up Operation	5127530
D3456-1	Washer	1 Ea (1 ea)	90-Start up Operation	5079335
D3457-1	Washer	2 Ea (2 ea)	90-Start up Operation	5088582
MS21042L3	Nut	8 Ea (8 ea)	90-Start up Operation	5094592
MS21042L4	Nut	12 Ea (12 ea)	90-Start up Operation	5109736
MS21043-4	Nut	1 Ea (1 ea)	90-Start up Operation	5092790
NAS1149C0463R	Washer	1 Ea (1 ea)	90-Start up Operation	5104373
NAS1149D0363J	Washer	8 Ea (8 ea)	90-Start up Operation	5107782
NAS1149D0463J	Washer	25 Ea (25 ea)	90-Start up Operation	5092780
NAS1149D0563J	Washer	8 Ea (8 ea)	90-Start up Operation	5050053

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-41A	8	122	0
	AN4-6A	12	726	0
	AN4C5A	1	62	0
	AN5-10A	4	253	0
	AN5-11A	8	88	0
	AN5-12A	4	357	0
	D206-642-341BL	1	0	0
	D206-648-013BL	1	0	0
	D2652	16	253	0
	D2712	10	537	0
	D2932-1BL	1	1	0
	D2933-1BL	1	1	0
	D2934	2	57	0
	D2935	2	62	0
	D2938-1BL	1	1	0
	D2939-1BL	1	1	0
	D3407-043BL	1	15	0
	D3413-1BL	1	4	0
	D3456-1	1	159	0
	D3457-1	2	43	0
	MS21042L3	8	2,035	0
	MS21042L4	12	2,459	0
	MS21043-4	1	792	0
	NAS1149C0463R	1	487	0
	NAS1149D0363J	8	2,153	0
	NAS1149D0463J	25	3,231	0
	NAS1149D0563J	8	1,372	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -357	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-311	SKIDTUBE INSTALLATION, LH
		X								D206-642-312	SKIDTUBE INSTALLATION, RH
			X							D206-642-313	SKIDTUBE INSTALLATION, LH
				X						D206-642-314	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-341	SKIDTUBE
						X				D206-642-357	WEARSHOE KIT (REPLACES -347)
							X			D206-642-349	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-351	SKIDTUBE
1	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D2650-5	SKIDTUBE ASSEMBLY
1								1		D4361-041	SKIDTUBE ASSEMBLY
2A					14			4		D2651-1	* PLUG ⁽¹⁾
2B					14			4		D2651-3	* O-RING ⁽¹⁾
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		MS27039-1-08	* SCREW ⁽¹⁾
5					2			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3-41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8						NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4						AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8	8	8						NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12	12	12						AN4-6A	BOLT
17	24	24	24	24						NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12						MS21042-4	NUT (OR MS21042L4)
20A					6	6				D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1				D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1				D4956-11	WEARSHOE (REPLACES D3535-11 + D3536-11)
23A					1	1				D4956-23	WEARSHOE (REPLACES D3535-23 + D3536-23)
24A					1	1				D4956-35	WEARSHOE (REPLACES D3535-35 + D3536-35)
26A					54	54				MS27039C1-08	SCREW
26B					54	54				NAS1149C0332R	WASHER (OR AN960C10L)
26C					54					ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34	1	1	1	1						AN4C5A	BOLT
35	1	1	1	1						NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1						D3413-1	RING (REPLACES D2655)
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER
40									2	D3414-041	GHW LUG (REPLACES D2659)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)

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